

Work Order ID 57611-2

Friday, April 09, 2010 2:44:09 PM

Page 1

Item ID: D4016-1

Revision ID:

Item Name: Hinge Half, Base

Start Date: 4/12/2010 Start Qty: 12.00 1 c

Required Date: 4/13/2010 Req'd Qty: 12.00 1 c

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4016	A								
100	Cut blanks as per folio	0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 1.00" LONG								
110		0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA869 AND DWG								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>AA</u>								
	DEBURR								

SPLIT

12 10/4/10

10 10.4.13

10

Work Order ID 57611

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Page 2

Item ID: D4016-1

Accept

Revision ID:

Item Name: Hinge Half, Base

Start Date: 4/12/2010 Start Qty: 12.00




Required Date: 4/13/2010 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Tooling: _____ Date: _____
SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	mf 10.4.13			10	0		
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	DIP 10/04/13			10	0		
160  Packaging Packaging	Identify as per dwg & Stock Location: 109 Memo	0.00 0.00	10/04/13					10	

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Item ID: D4016-1

Accept

Revision ID:

Item Name: Hinge Half, Base

Start Date: 4/12/2010 Start Qty: 12.00

Required Date: 4/13/2010 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/14 HJ

MF

10-4-14

Picklist Print

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Work Order ID: 57611



Parent Item: D4016-1



Parent Item Name: Hinge Half, Base

Start Date: 4/12/2010

Required Date: 4/13/2010

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

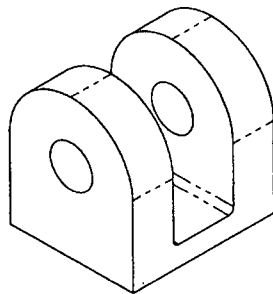
Start Qty: 12.00

Required Qty: 12.00

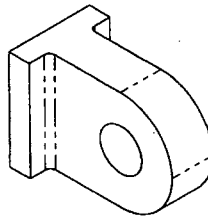
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No			100	f	16.3000	1.0105			
304 bar 1.50 X1.50												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT54	16.3	
108381	12	
112752	4.3	

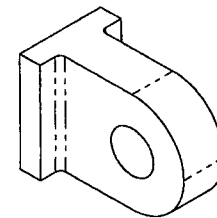
1.0105 2/10/04/10



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

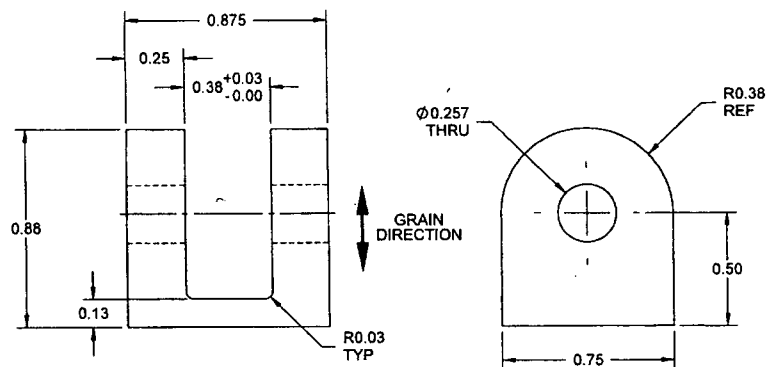


D4016-5 HINGE HALF, LIGHT LID

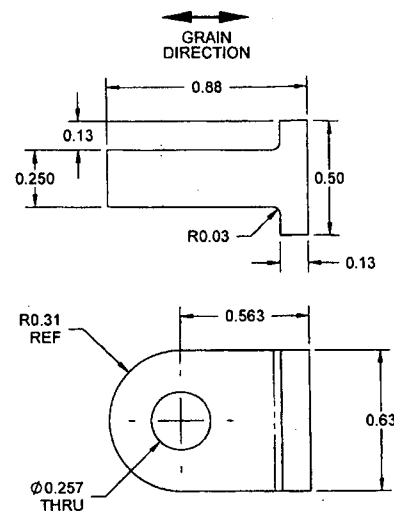
H-51611

RELEASED
2010-02-16
MD

A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D4016	SHEET 1 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	JS	BASKET HINGE	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16
AN

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
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